



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200

RBE350A93-3312-03
Job Sheet 181036



Part No: RBE350A93-3312-03

Job Qty: 5 ea

Part Name: Tail Rotor Hub Bushing Replacement Tool



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 7/19/18

Job Tracking No:

Due Date: 8/7/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBE350A93-3312-03 Rev G IPP Rev A 18.01.23 New issue DP Verify DD/IPP Rev B 18.03.08 DWG update Rev. G DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	8/7/18	8/7/18	0.00	0.00	Start Up Small Fab-4		MLC
100	Small Fab	5 pcs	8/7/18	8/7/18	0.00	0.50	Small Fab-9		MLC DAS 38
110	QC	5 pcs	8/7/18	8/7/18	0.00	0.00	QC5		MLC 38
130	Packaging	5 pcs	8/7/18	8/7/18	0.00	0.00	Packaging3-2		MLC 38
140	QC21-FG	5 Ea	8/7/18	8/7/18	0.00	0.00	QC21		DAS 38

Part Op 100 - Assemble as per DWG sheet 1.
Descriptions: 130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
90685A110	Hex Nut M12 X 1.75mm	5 Ea (1 ea)	90-Start up Operation	5089114
95327A708	Hex Head Screw M12 X 1.75mm x 100mm LG. (Mcmaster)	5 Ea (1 ea)	90-Start up Operation	5089135
RBE350A93-3312-03-1	Receiver	5 Ea (1 ea)	90-Start up Operation	5082117
RBE350A93-3312-03-3	Remover / Installer -PO	5 Ea (1 ea)	90-Start up Operation	5094930
RBE350A93-3312-03-5	Seat	5 Ea (1 ea)	90-Start up Operation	5092737
RBE350A93-3312-03-7	Washer	5 Ea (1 ea)	90-Start up Operation	5092754

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	90685A110	5	42	0
	95327A708	5	42	0
	RBE350A93-3312-03-1	5	11	0
	RBE350A93-3312-03-3	5	0	0
	RBE350A93-3312-03-5	5	48	0
	RBE350A93-3312-03-7	5	48	0

Part Specifications

Specifications could not be found.

Plex 7/19/18 4:15 PM dart.logan.david



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Container No: S098735



Part: RBE350A93-3312-03

Job No: 181036

Serial No/Batch: S098735

Revision: G

Inspector:

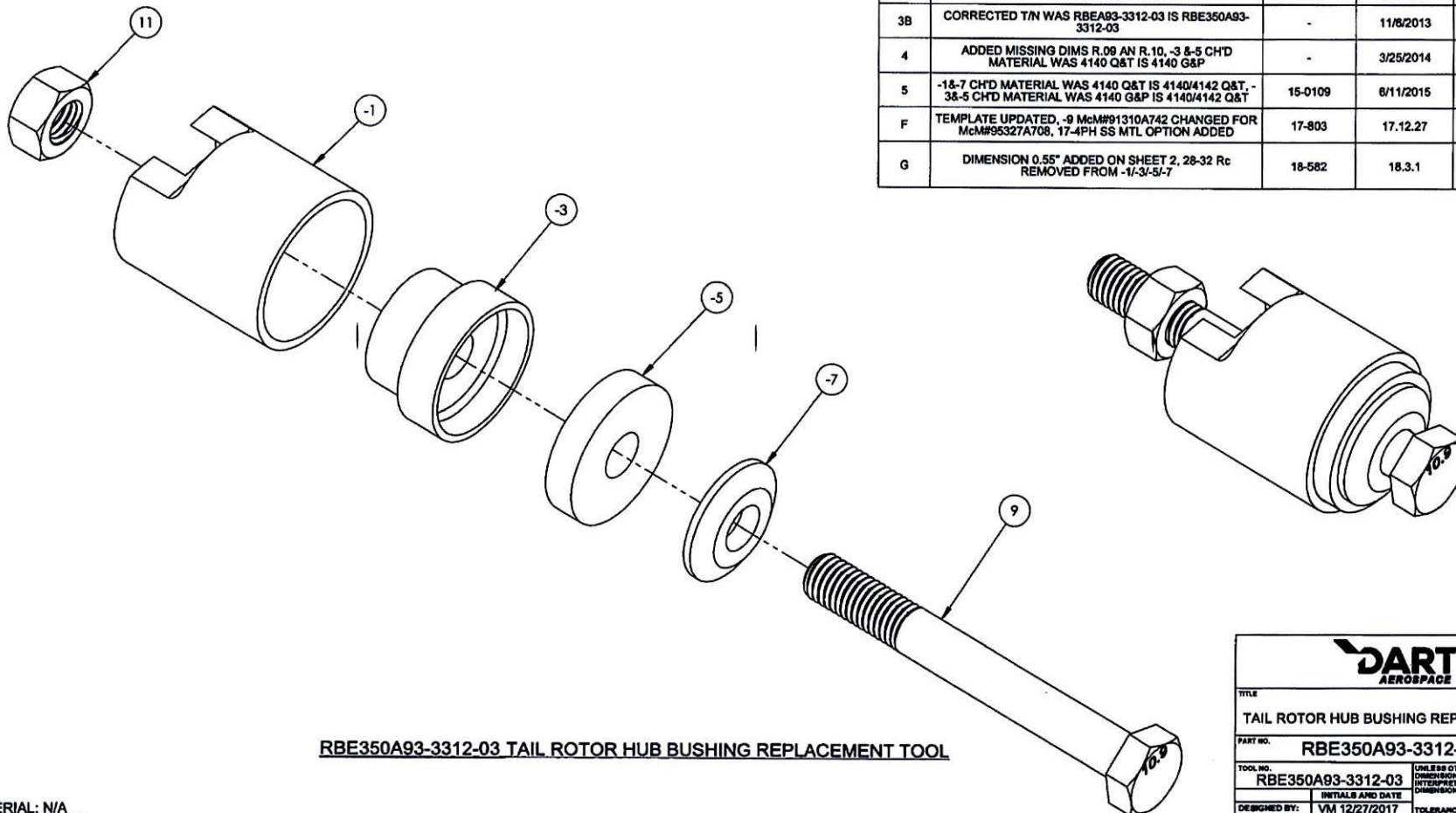
Exp Date:

Instructions:

Date: 08/02/18

ITEM #	QTY	PART #	TITLE
-1	1	RBE350A93-3312-03-1	RECEIVER
-3	1	RBE350A93-3312-03-3	REMOVER / INSTALLER
-5	1	RBE350A93-3312-03-5	SEAT
-7	1	RBE350A93-3312-03-7	WASHER
9	1	McMaster#95327A708	HEX HEAD SCREW M12 x 1.75 x 100mm L.G.
11	1	McMaster#90685A110	HEX NUT M12 x 1.75

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
1	-01 ADDED S/N, "MADE IN USA"	-	4/29/2009	RJC	-
2	CHD ALL HOLES FROM 12.2mm TO 12mm FOR BETTER TOOL ALIGNMENT, CHANGES MADE TO MATCH CURRENT HELI-PRODUCTS TOOLS AND MORE OPEN TOLERANCES, -01 CHD DEPTH FROM .984 TO 1.06, ADDED R12 FOR LOOSER TOLERANCE, -03 CHD DIM FROM DIA 1.480 TO 1.487, FROM .939 TO .945, ADDED R.03, -05 CHD DIM WAS DIA 1.480 IS 1.487	-	9/30/2009	WP	RW
3	-01 CHD DIM WAS DIA 1.500 IS DIA 1.500 +0/-0.003	-	12/15/2010	RJC	RW
3A	-03 ADDED MISSING DIM .325	-	9/20/2011	RJC	GE
3B	CORRECTED T/N WAS RBEA93-3312-03 IS RBE350A93-3312-03	-	11/8/2013	RJC	RW
4	ADDED MISSING DIMS R.09 AN R.10, -3 & -5 CHD MATERIAL WAS 4140 Q&T IS 4140 G&P	-	3/25/2014	DPD	GE
5	-1& -7 CHD MATERIAL WAS 4140 Q&T IS 4140/4142 Q&T, -3& -5 CHD MATERIAL WAS 4140 G&P IS 4140/4142 Q&T	15-0109	6/11/2015	RJC	JAG
F	TEMPLATE UPDATED, -9 McMaster#91310A742 CHANGED FOR McMaster#95327A708, 17-4PH SS MTL OPTION ADDED	17-803	17.12.27	VM	ML
G	DIMENSION 0.55" ADDED ON SHEET 2, 28-32 Rc REMOVED FROM -1/-3/-5/-7	18-582	18.3.1	VM	ML



RBE350A93-3312-03 TAIL ROTOR HUB BUSHING REPLACEMENT TOOL

NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) SPEC: N/A
 5) BREAK ALL SHARP EDGES: N/A
 6) IDENTIFICATION: N/A

DART AEROSPACE Newbury, Ontario, Canada	
TITLE TAIL ROTOR HUB BUSHING REPLACEMENT TOOL	
PART NO. RBE350A93-3312-03	REV G
TOOL NO. RBE350A93-3312-03	
INITIALS AND DATE	
DESIGNED BY: VM 12/27/2017	TOLERANCES: UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES
DRAWN BY: VM 03/01/2018	SOCK ± .005
CHECKED BY: VM 03/01/2018	XX ± .01
MFG REVIEW BY: JFC 03/01/2018	ANGLES ± 1/8°
APPROVED BY: ML 03/01/2018	SURFACE ROUGHNESS
SCALE: NTS	SHEET 1 OF 5
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